



NOTES:

- 1) MATERIAL: MAKE FROM D5609-1
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE DART P/N "D130-1048-141" AND S/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON INSIDE OF CUFF
- 7) WEIGHT: 17.8 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
- 9) MASK THESE HOLES PRIOR TO PRIME/PAINT
- 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038 AFTER DRILLING.
- 11) CHAMFER ID 0.06 X 45°

RELEASED

2019 JUN 19 NO
ECN19-625

APPROVED

B	REDRAWN, LPI AFTER DRILLING WAS PRIOR TO DRILLING, ADDED CHAMFERS, DIM 7.48 C TO C WAS 7.274 PERPENDICULAR TO SECTION LINE, 17.8 lbs WAS 17.34 lbs (ADDED WEIGHT OF PAINT), DIM 14.856 WAS 14.656	ZF	18.12.18
A	NEW ISSUE	ZF	18.06.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D130-1048-141 REV. B SHEET 1 OF 1	
MFG. APPR.	JFS		
APPROVED	NO	TITLE FWD X-TUBE (EC130) SCALE NTS	
DE APPR.	CP		
DATE	18.12.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	